

303 HEX .500

Work Order ID 82072

82072

Page 1

Thursday, March 22, 2012 1:22:55 PM

Item ID: D3622-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Ball Stud

Start Date: 3/22/2012 Start Qty: 20.00

20

Required Date: 3/29/2012 Req'd Qty: 20.00

20

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

ML5

Date:

12/03/22

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3622

Rev C

100

0.00

100

Hardinge

Hardinge CNC LATHE SMALL

Memo

0.00

Hardinge CNC Lathe Small

1-TURN AS PER FOLIO FA686 & DWG D3622,

FOLIO REV: AADWG REV: 2

2-DEBURR AS REQUIRED

29 12.5.10

35

4

110

0.00

110

QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

29 12.5.10

35

4

120

0.00

120

QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

OK 12/05/12

35

4

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 82072

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Page 2

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20

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Required Date: 3/29/2012 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: 5158

0.00

130

Packaging

Memo

0.00

Packaging

35 505 12/05/14

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

12/5/14 ME12-05-14

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NOTE: Date & initial all entries

Picklist Print

Thursday, March 22, 2012 1:22:59 PM

Page 1

Work Order ID: 82072

82072

Parent Item: D3622-1

D3622-1

Parent Item Name: Ball Stud

Start Date: 3/22/2012

Required Date: 3/29/2012

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A New Issue 07-04-24 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M303H0.500

Purchased

No

100

f

0.0915

0.108

2.273684

**

12.5.10

M303H0 500

303 HEX BAR .500

Location

Loc Qty

Loc Code

MAT037

0.0915

109778 ✓

0.0915

3.762

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	82072
Description: Ball Stud		Part Number:	D3622-1
Inspection Dwg: D3622 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.58	+/-0.030	.563	/		2x.02	
0.50	+/-0.030	.499	/			
Ø0.394	+/-0.010	.387	/			
Ø0.310	+/-0.010	.308	/			
Ø0.215	+/-0.010	.211	/			
0.155	+/-0.010	.150	/			
0.313	+/-0.010	.318	/			
0.478	+/-0.010	.478	/			
0.630	+/-0.010	.636	/			
0.125	+/-0.010	.135	/			
0.563	+/-0.010	.561	/			
1.19	+/-0.030	1.182	/			
0.3125-24UNF-3A	+0.000/-0.072	.3A	/			
M.O.W.	Min = 0.3336 Max = 0.3363	.335	/			

Measured by:	RP
Date:	12.5.12

Audited by:	AK
Date:	12/05/12

Preliminary Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A	08.04.15	New Issue	KJ/DD	
B	10.02.02	Dwg Rev updated	KJ	
C	11.02.18	Dimensions updated per Dwg Rev C	KJ	

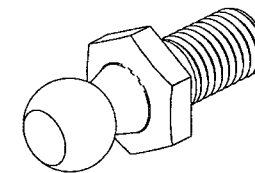
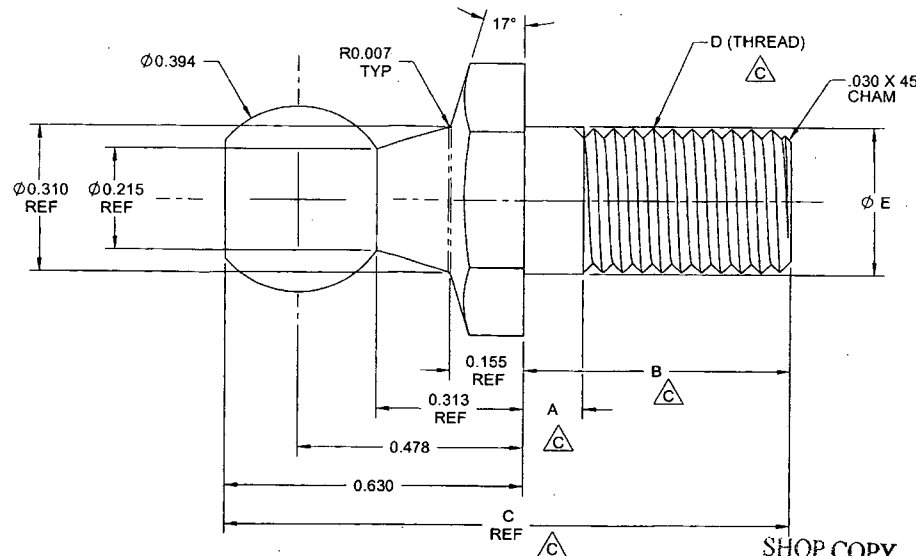
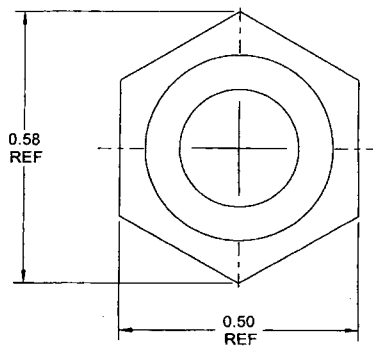
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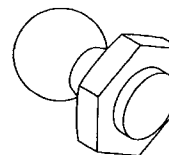
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NOTE: Date & initial all entries



D3622-1 BALL STUD SHOWN



D3622-11 BALL STUD SHOWN

PART NUMBER	DIM			WEIGHT (LBS)	THREAD D	Ø E	
	A	B	C			MIN	MAX
D3622-1	0.125	0.563	1.19	0.03	0.3125-24UNF-3A	0.3053	0.3125
D3622-3	0.125	0.563	1.19	0.03	0.1875-32UNF-3A	0.1840	0.1900
D3622-5	0.090	0.900	1.53	0.04	0.3125-24UNF-3A	0.3053	0.3125
D3622-7	0.060	0.330	0.96	0.03	0.3125-24UNF-3A	0.3053	0.3125
D3622-9	0.090	1.160	1.79	0.04	0.3125-24UNF-3A	0.3053	0.3125
D3622-11	0.060	N/A	0.69	0.02	NOT THREADED	0.270	0.300
D3622-13	0.090	0.680	1.31	0.03	0.3125-24UNF-3A	0.3053	0.3125

D3622-X BALL STUD

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 82072 MCT
12/03/22

RELEASED
2010-09-23

NOTES:

- 1) MATERIAL: AISI 303 HEX BAR
REF DART SPEC M303H0.500
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENT P/N D3622-X & B/N PER QSI 044
- 7) WEIGHT: SEE D3622-X TABLE

C	SHEET 1: ADD -5, -7, -9, -11 & -13. ADD D3622-X TABLE. SHEET 2 DELETED	JPH	10.07.20
B	ADD -3 (SHEET 2)	HS	09.09.18
A	NEW ISSUE	MB	07.04.13
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3622	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		BALL STUD	NTS
DATE	10.07.20	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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